

Date: Monday, 3/13/2006 7:30:24 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 26211D		
Estimate Number	: 10380		
P.O. Number	: N/A	Part Number	: D30657
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D3065 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 24408D	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>06.03.13</u>	Qty:	60 Um: Each
Comment	: Est:C 02.11.06 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: M19295

~~M100712~~
~~06.05.05~~

SAD 06:05:16

(60)

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 4.580" x 4.500" Grain along 4.500"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA181 and Dwg D3065
 Stack of 15
 Identify as D3065-7

Water Jet Dwg Rev A2
 Prog Rev A2

SAD 06:05:16

(61)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.05.16

5.0	QC8	SECOND CHECK
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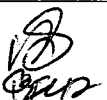
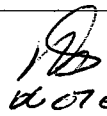
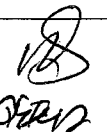
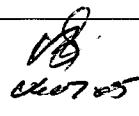
Comment: SECOND CHECK

06.05.17

(61)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 0607/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2/07/05	7	1 part are map		Scrap + destroy	SB 0607/05	 060705		 060705

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:24 AM
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Process Sheet

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Drawing Name: STEP SPACER

Job Number: 26211D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

M.F. 06-05-24- (60)
SAD 06:05:16 60

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3065

SB 06/06/03 (60)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-05 (60)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-15 (60)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SAD 06:07:05 60

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SB 06/07/05 (60)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/07/06 (60)

Job Completion



06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

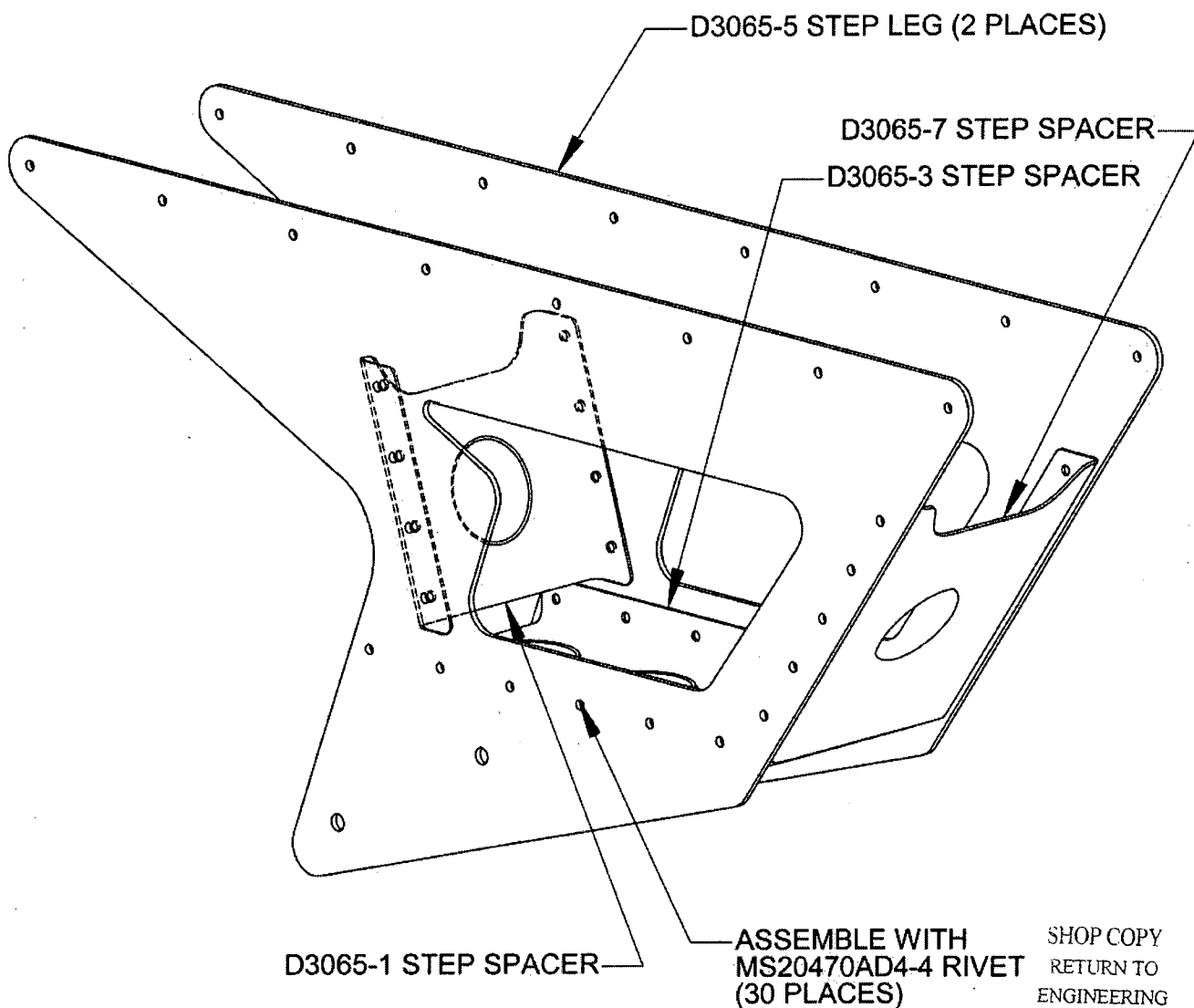
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED
02.09.20 *#*



D3065-041 STEP LEG ASSEMBLY

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WORK ORDER
NO. 26211D

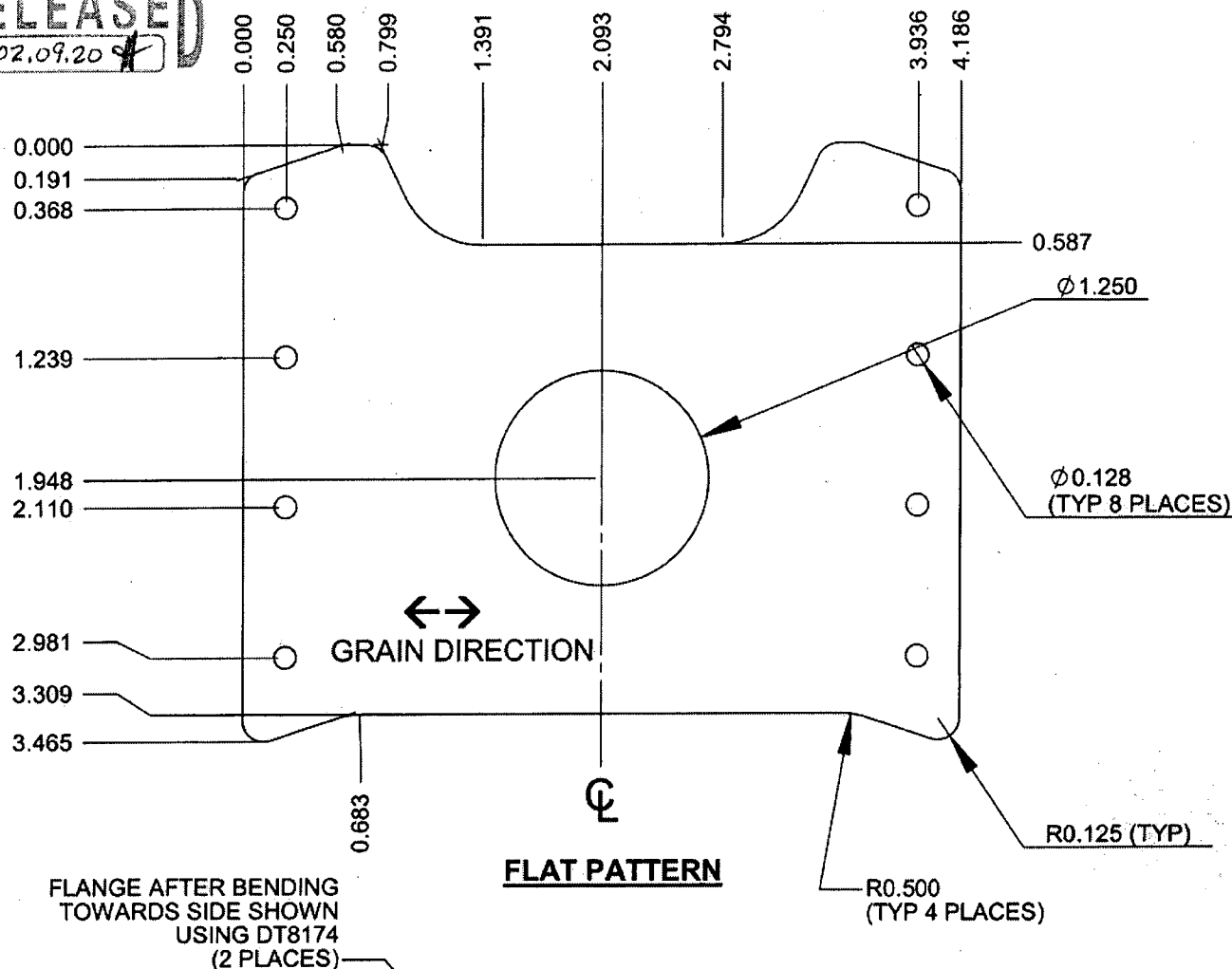
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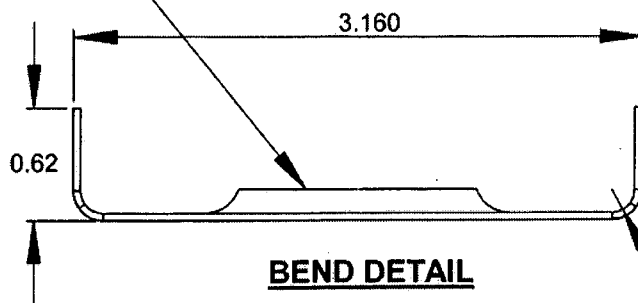


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *[Signature]*



FLAT PATTERN



BEND DETAIL

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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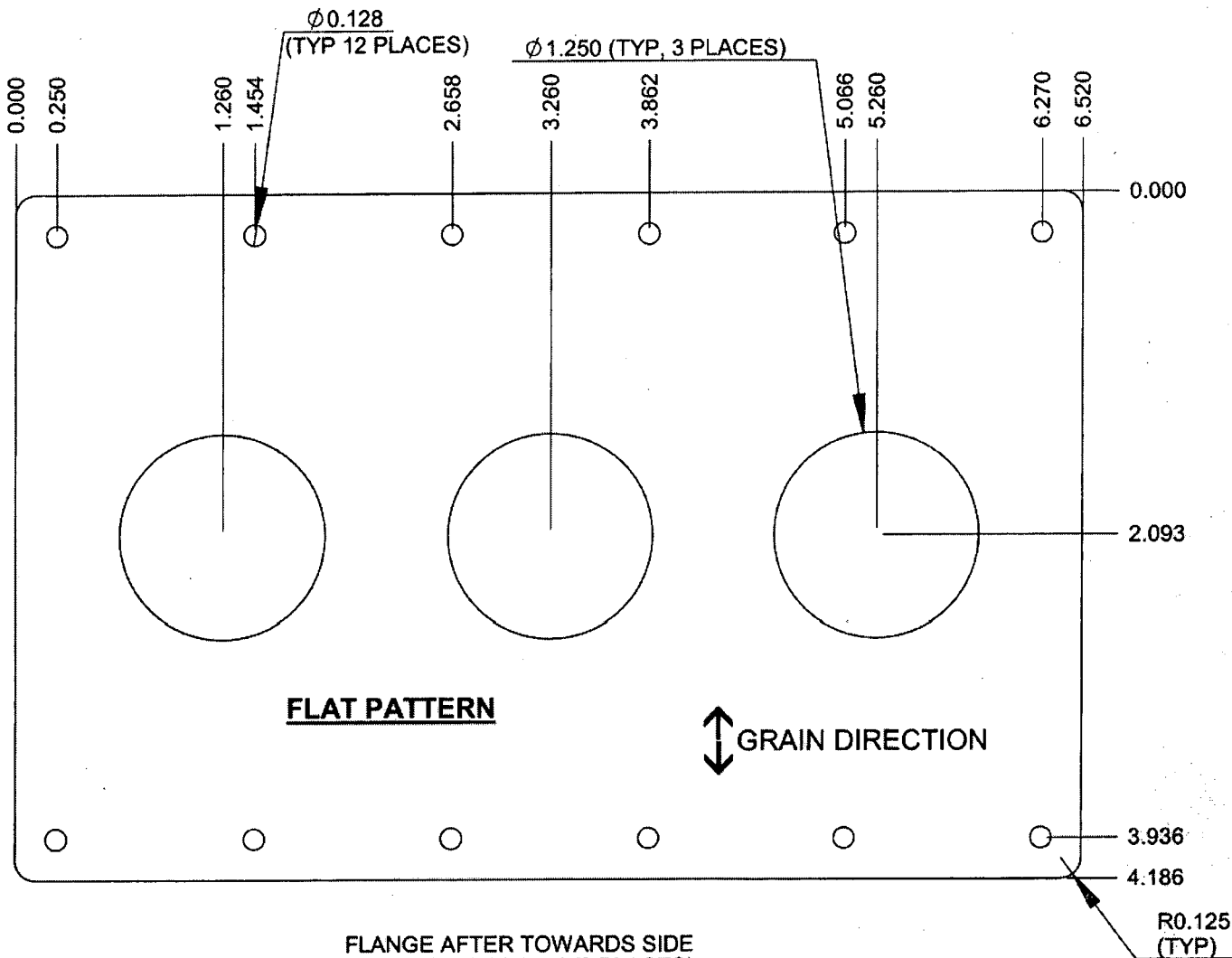
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02.09.20

DART



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLAT PATTERN

GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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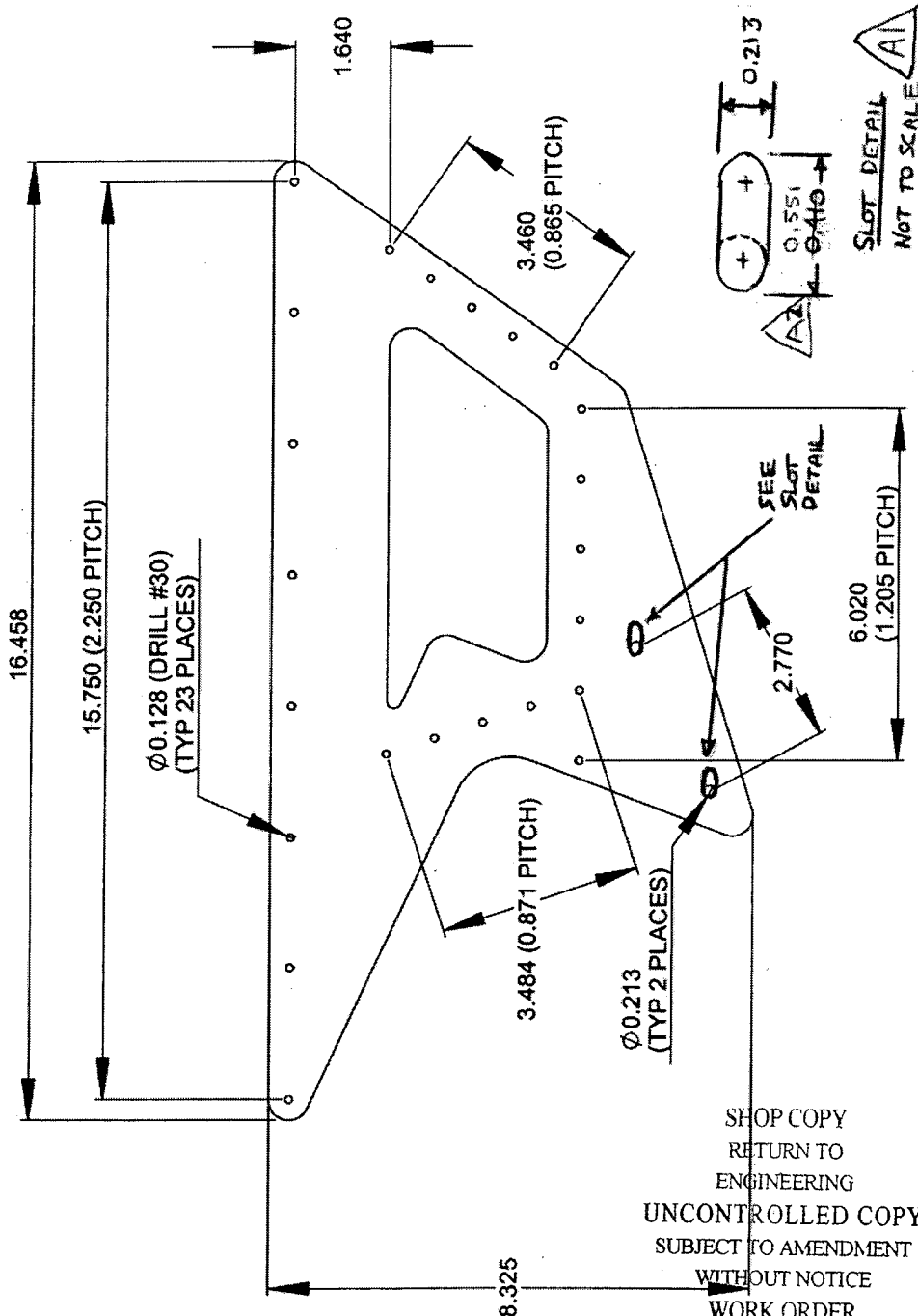
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED
02.09.20 *[Signature]*



- D3065-5 STEP LEG**
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 - 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

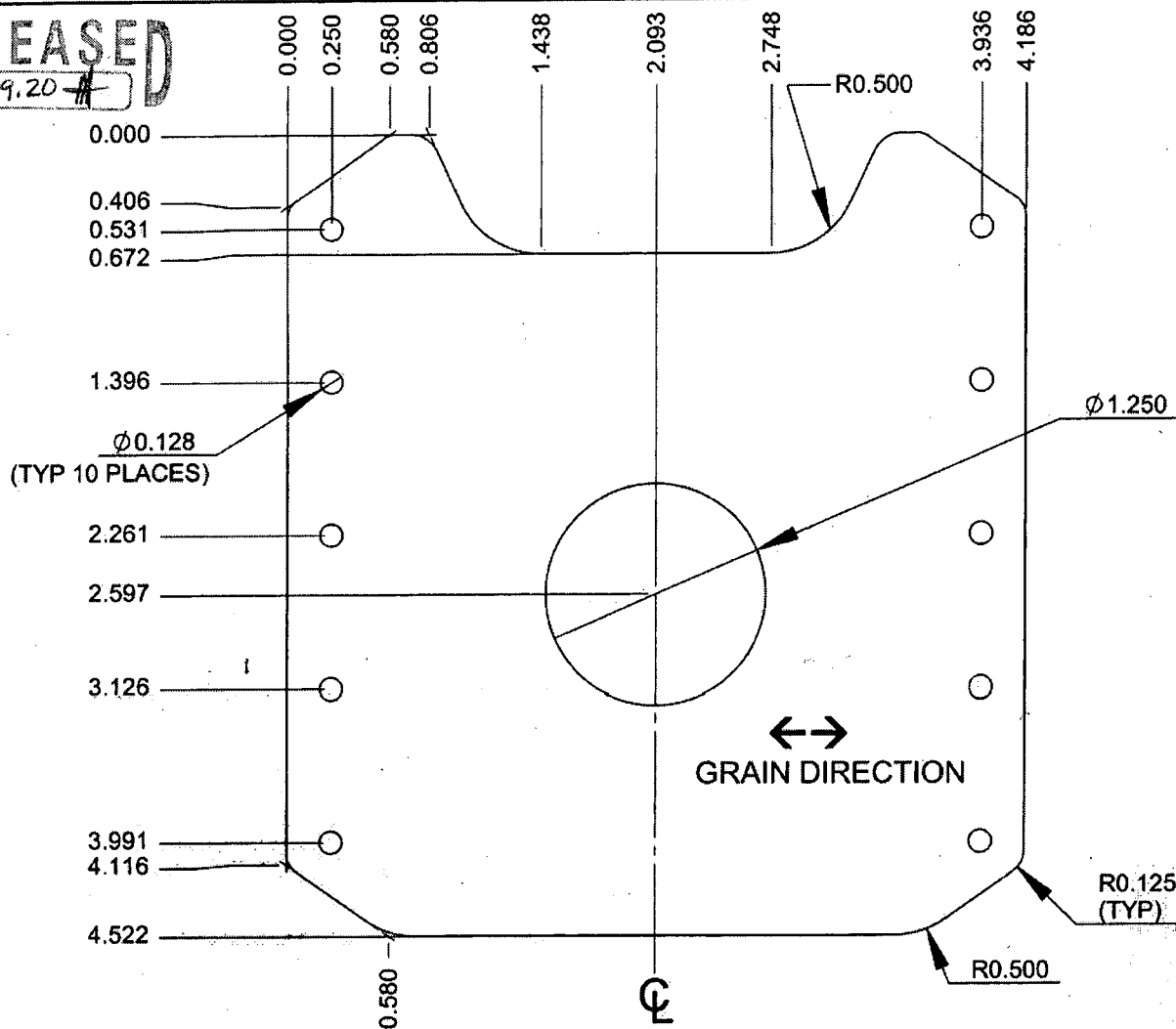
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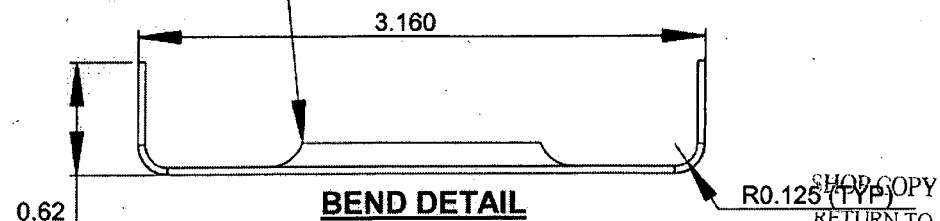
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *#*



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. **26211 D**

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